

Work Order ID 110092

December-17-13 9:14:49 AM

110092

Page 1

Item ID: D3915-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Light Lid Assembly, Long Basket
 Start Date: 12/13/13 Start Qty: 3.00 *3*
 Required Date: 12/17/13 Req'd Qty: 3.00 *3*
 Reference: Cust Item ID:
 Customer:

Approvals: Process Plan: MLS Date: 12-12-13 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3915	E

100 Weld per dwg A/R Aluminum rod Batch: B123823 0.00
 Large Fab

100
 Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3915 using DT9606A. When welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld.

****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME****

2- weld hinge, label plate and Mounting plates as per dwg D3915

CC 14-1-29

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110
 QC
 Quality Control

Memo

0.00

DAS 9 9-89

Work Order ID 110092

December-17-13 9:14:49 AM

110092

Page 2

Item ID: D3915-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Light Lid Assembly, Long Basket
 Start Date: 12/13/13 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 12/17/13 Req'd Qty: 3.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							DAS 9 9-89
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing	***ENSURE TO RINSE CAREFULLY ACID AND ALODINE***								
140	Weld per dwg A/R Aluminum rod Batch <u>M12763</u>	0.00							
140									
Large Fab	Memo	0.00							
Large Fab	1- weld (4) corners								

① 14-01-30 DAS
 1 HG 14-1-30
 1 14-01-30

Work Order ID 110092

December-17-13 9:14:49 AM

110092

Page 3

Item ID: D3915-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Light Lid Assembly, Long Basket

Start Date: 12/13/13 Start Qty: 3.00

~~*3*~~

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 3.00

~~*3*~~

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

150

QC

Memo

0.00

Quality Control

155

QC6- Inspect dimensions to drawing

0.00

155

QC

Memo

0.00

Quality Control

inspect fit of lid with base

157

Chemical Conversion Coat per QSI005 4.1

0.00

157

HandFinish

Memo

0.00

Hand Finishing

1- realodine corners
do not acid etch

December-17-13 9:14:49 AM

Page 4

Quality Control

Work Order ID 110092

December-17-13 9:14:49 AM

110092

Page 5

Item ID: D3915-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Light Lid Assembly, Long Basket
 Start Date: 12/13/13 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 12/17/13 Req'd Qty: 3.00 *3* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Assemble as per dwg	0.00							
180									
HandFinish	Memo	0.00							
Hand Finishing	1- Install webbing as per dwg								
	2- Install placard and label as per dwg								
190	QC5- Inspect part completeness to step on W/O	0.00							
190									
QC	Memo	0.00							
Quality Control									
200	Identify as per dwg & Stock Location: <u>W/O</u>	0.00							
200									
Packaging	Memo	0.00							
Packaging									

DAS
27
9-59

4/1/3/

04030-043/ B1101156

1x 1 10/05/13

1

1x 1 11/04/13

Work Order ID 110092

110092

Page 6

December-17-13 9:14:49 AM

Item ID: D3915-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Light Lid Assembly, Long Basket

Start Date: 12/13/13 Start Qty: 3.00 *3*

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 3.00 *3*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

MCS 1401-31

14-01-31

Picklist Print

December-17-13 9:14:48 AM

Page 1

Work Order ID: 110092
Parent Item: D3915-041
Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 12/13/13
Start Qty: 3.00

Required Date: 12/17/13
Required Qty: 3.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C add realodine DD 10.04.26 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 13.07.08 as per dwg rev.D DD verf:JLM IPP REV:D 13.08.21 DWG REV.E / ECN 13-624 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2957 Mounting Plate		Manufactured	No			100	Each	10.0000	4	24	CC	14-1-29	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		10							
				108993		10							
D3915-1 Rib		Manufactured	No			100	Each	0.0000	2	82	CC	14-1-29	
D4016-5 Hinge Half, Light Lid		Manufactured	No			100	Each	20.0000	3	83	CC	14-1-29	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		20							
				105052		20							
D4019-3 Rib		Manufactured	No			100	Each	0.0000	3	13	CC	14-1-29	
D4029-041 Webbing (Long Basket)		Manufactured	No			180	Each	3.0000	1	3			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST489		3							
				104994		3							
D4035-047 Lid Rib Assembly, Aft (Light)		Manufactured	No			100	Each	5.0000	2	104554	CC	14-1-29	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		5							
				104422		1							
				107767		4							



Picklist Print

December-17-13 9:14:48 AM

Page 2

Work Order ID: 110092

Parent Item: D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 12/13/13

Required Date: 12/17/13

Start Qty: 3.00

Required Qty: 3.00

D4056-1
Label Plate

Manufactured No

100 Each 13.0000 1

~~21X~~ CC 14-1-29

Location

Loc Qty

Loc Code

WA004

13

85016

13

MS20600-AD4W4
Rivets

Purchased No

180 Each 3,534.0000 34

102

DAS
33
9-89

Location

Loc Qty

Loc Code

ST311

3474

123900

350

125406

24

125577

3100

125577

ST506

60

125654

60

NAS1149DN949J
Washer

Purchased No

180 Each 431.0000 34

102

DAS
33
9-89 14-01-31

Location

Loc Qty

Loc Code

ST293

431

120833

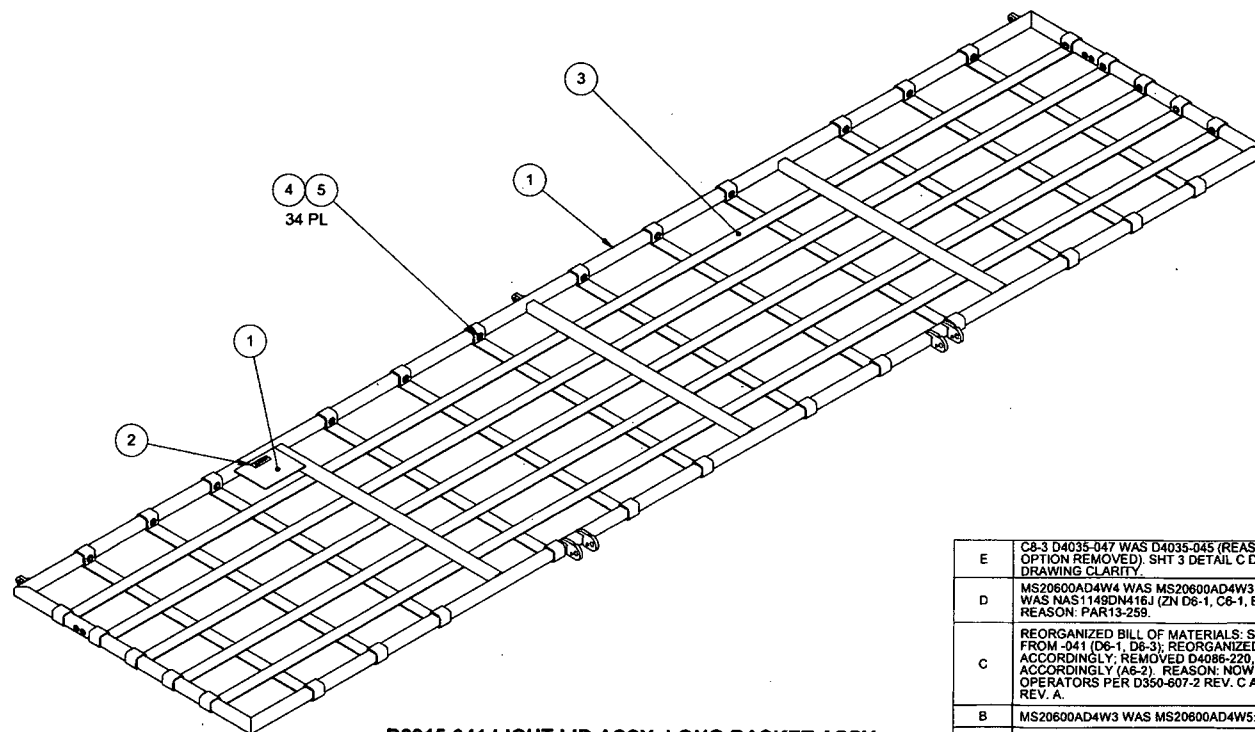
2

m126926

429

126926

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3915-041	LIGHT LID ASSY, LONG BASKET ASSY
1	1	D3915-101	BASKET LID WELDMENT ASSY
2	1	D2728-1	DART LOGO LABEL
3	1	D4029-041	WEBBING (LONG BASKET)
4	34	NAS1149DN949J	WASHER
5	34	MS20600AD4W4	RIVET, BLIND, PAN-HEAD



D3915-041 LIGHT LID ASSY, LONG BASKET ASSY

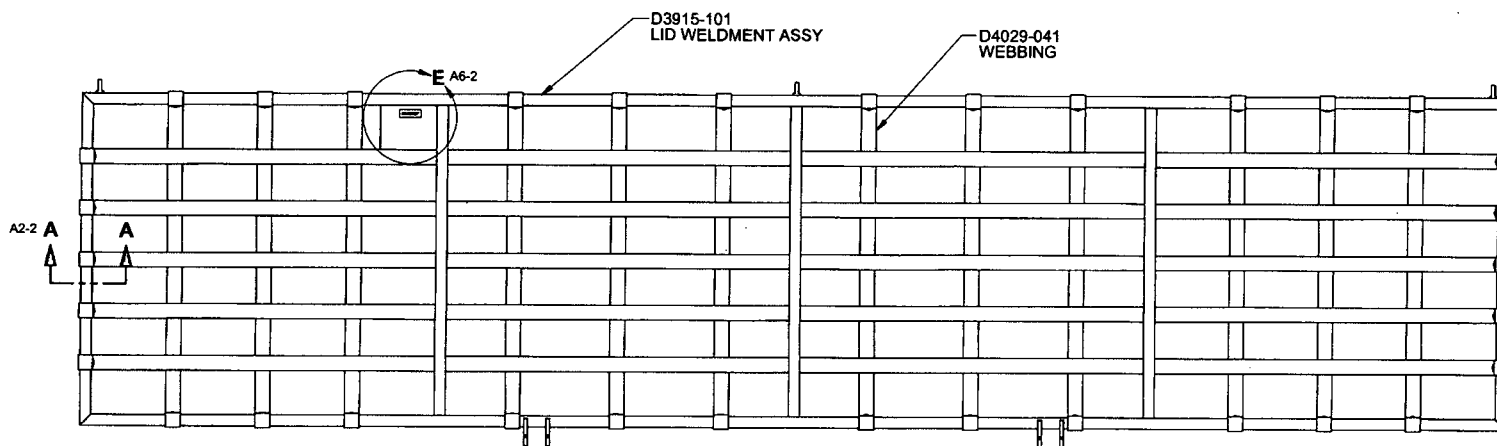
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.98 lbs

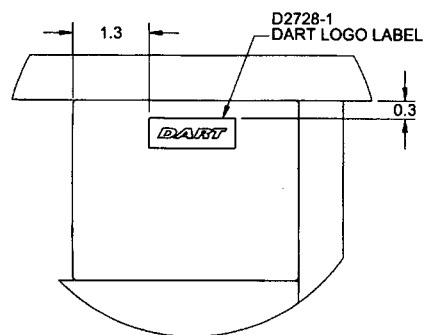
110092 mcs
13-12-19

RELEASED
2013-08-16

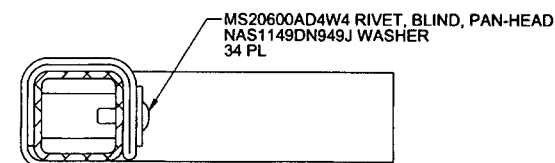
E	C8-3 D4035-047 WAS D4035-045 (REASON PROPARM OPTION REMOVED). SHT 3 DETAIL C DELETED FOR DRAWING CLARITY.	AJS	13.07.18
D	MS20600AD4W4 WAS MS20600AD4W3; NAS1149DN949J WAS NAS1149DN416J (ZN D6-1, C6-1, B1-2). REASON: PAR13-259.	MB	13.06.19
C	REORGANIZED BILL OF MATERIALS: SEPARATED -101 FROM -041 (D6-1, D6-3); REORGANIZED VIEWS ON SHT 3 ACCORDINGLY; REMOVED D4086-220, UPDATED VIEW E ACCORDINGLY (A6-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	MS20600AD4W3 WAS MS20600AD4W5: BOM & (B1-2)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3915 REV. E SHEET 1 OF 4 SCALE LIGHT LID ASSY-LONG BASKET NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR QUANTIFIED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	AJS		
CHECKED	UP		
MFG. APPR.	SA		
APPROVED	WJ		
DE APPR.	WJ		
DATE	13.07.18		



D3915-041 LIGHT LID ASSY, LONG BASKET



DETAIL E D6-2

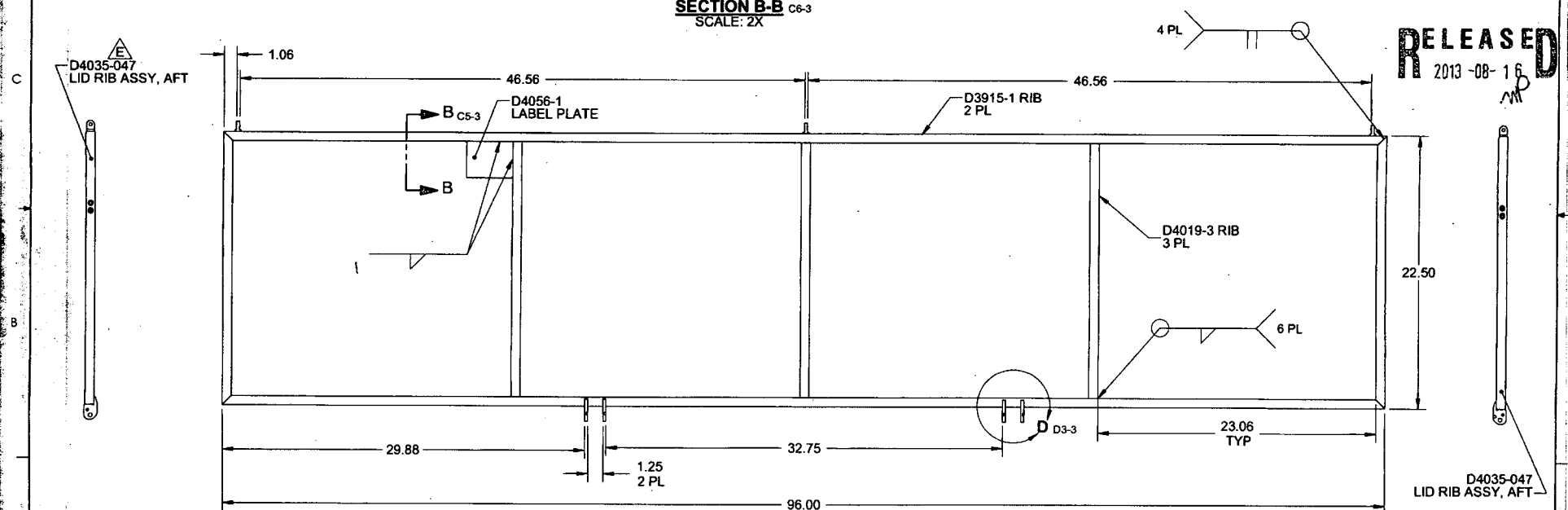
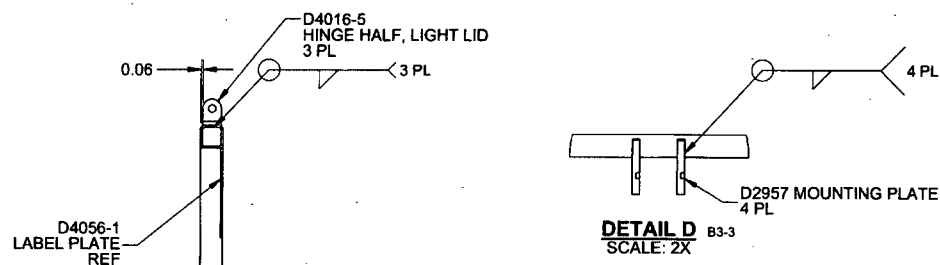


SECTION A-A C8-2
SCALE: 8X

RELEASED
2013-08-16

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3915	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LIGHT LID ASSY-LONG BASKET INTS	
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

ITEM	QTY	P/N	DESCRIPTION
	X	D3915-101	BASKET LID WELDMENT ASSY
1	2	D3915-1	RIB
2	4	D2957	MOUNTING PLATE
3	3	D4016-5	HINGE HALF, LIGHT LID
4	3	D4019-3	RIB
5	2	D4035-047	BASKET LID RIB ASSY, AFT (LIGHT)
6	1	D4056-1	LABEL PLATE, 350 LIGHT BASKET



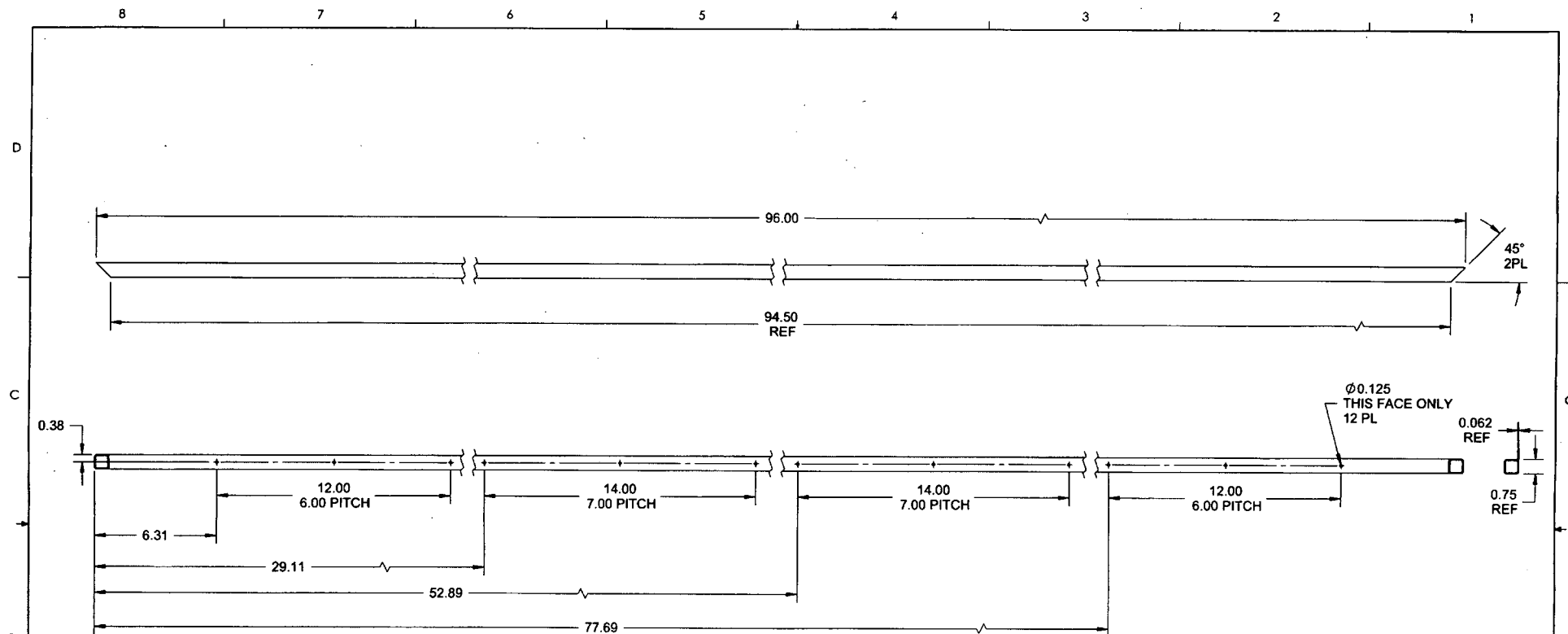
D3915-101 BASKET LID WELDMENT ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.82 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3915	REV. E
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LIGHT LID ASSY-LONG BASKET	
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2013-08-16



D3915-1 RIB

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC. M6061T6TS0.750W.062
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.49 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3915	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID ASSY-LONG BASKET	Nts
DATE	13.07.18	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED
2013-08-16
WD